96701

3106

Page 1

January-31-13 9:54:52 AM Item ID: D2938-1 Accept *N900040100* Setup Start **Revision 1D:** Item Name: Saddle LH Out, 206 *19* Start Date: **Start Qty: 12.00** 1/31/13 **Cust Item ID:** Required Date: 2/22/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: MLJ Approvals: Date: 13=01-31 Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D2938 Rev C 100 0.00 HAAS CNC VERTICAL MACHINING #1 *100* 3/02/09 12 Ø HAAS 1 0.00 Memo HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per 110 0.00 CONVENTIONAL MILLING MACHINE *110* 20 Mill Conv 13/02/09 0.00 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet 120 QC1- Inspect dimensions to dimension sheet 0.00 *120* 13/02/09 QC 0.00 Memo Quality Control

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE

											+	QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
Part I	No.				1	Rework Scrap Use-as-is Work Order Update		I Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root			ſ]	Descri	ption of work order update	l	nitial	Δι	ction	····	Sign &			
Cause		Date	Step	Qty	ì	or Non-conformance	1	ef Eng		cription	}	Date	Verificatio	n	QC Inspector
Doc/Data							1	Ü							
Equip/Tooling				:											
Operator															
Material							1								
Setup															
Other									- - - -			'			ļ
Process															<u> </u>
Supplier]									!			•
Training							1				:				
Unapproved															<u> </u>
							AULT	CATE	GORY						
Landi	ng (1				General				ſ	_	l			7
	_	Bending				Bend		Grain			\vdash	Ovalized		\vdash	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa				Over/Under		\vdash	Temperature/Cure
	L	Cracks				Broken/Damaged		•	ion Incomplete	6	ш	Part Incorre		\vdash	Weld
		Crushed/	Crimped.			Burrs	-		ions Incomplete	/Unclear		Part Lost/Mi	issing	<u></u>	Wrong Stock Pulled
	<u> </u>	Cuffs			<u> </u>	Contamination	—		enance		\vdash	Part Moved	Muses		
	<u> </u>	Heat Trea		T b		Countersink	 	Mislabe				Positioned V	-	\Box	Other
	<u> </u>	Inspectio		rube	<u> </u>	Cut Too Short Drill Holes		Misread	1	İ	لـــا	Power Loss/	ourge	<u></u>	Torner
	<u> </u>	Ripples in Torque W		· verusia	<u> </u>	4	\vdash	Offset	Calibration						
	<u> </u>	Turning S			" 	Drawing Finish	\vdash		Sequence			· · ·			
ļ	l	Frairing 2	equence		1	Limpii	- 1 - 1'	out of .	reductive						

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-31-13 9:54:52 AM Item ID: D2938-1 **Revision 1D:** Saddle LH Out. 206 Item Name: **Start Date:** 1/31/13

Accept

N900040100

Setup Start *NS1*

Required Date: 2/22/13

Start Qty: 12.00 Req'd Qty: 12.00

12 *12*

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
1	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool # Plan Code	Accept Reject Reject Insp. Qty Qty Number Stamp
130	QC8- Inspect parts	second check	0.00		$\mathcal{DA}\mathcal{C}$
130	Memo		ه. ط	13/02/10	12 0 08

140

Chemical Conversion Coat per QSI005 4.1

0.00

140 HandFinish

Hand Finishing

Quality Control

Memo

0.00

12 MB-2-14

NCR: Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE			
										QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		•	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	П	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		İ										
Operator		ŀ										
Material .												
Setup " '												
Other								<u> </u>				
Process												
Supplier												[
Training										:		
Unapproved			<u> </u>			1		<u>.</u>				
					· F	AUL	T CATE	GORY				
Landing (Gear				General							

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Broken/Damaged

DQA:

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Date:

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Quality Control

96701

Page 3

January-31-13 9:54:52 AM Item ID: D2938-1 Accept *N900040100* Setup Start Revision ID: Saddle LH Out. 206 Item Name: *12* **Start Date: Start Qty: 12.00** 1/31/13 **Cust Item ID:** Required Date: 2/22/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: ____ Date: Approvals: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours Qty** Qty Number Stamp Code 145 Spray Painting per OSI005 4.2 0.00 *145* 12 Ø Ø SprayPaint 0.00 Memo Spray Painting PRIME B 117319 START: 6:00 FINISH: 6:45 DELFLEET BLUE B 121722 DELFLEET CLEAR B 118093 START: 12:30 FINISH: 1:30 155 QC14- Inspect Spray Paint 0.00 *155* QC 0.00 Memo

			DQA:	Date:
ICR·	Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE		

NCR: 1	es	/ NO				WORK ORDER NON-	CON		WIANCE / OF		QA Closed:	Date:	
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-					Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	10.					Work Order Update]		Large Fab	Composite	1100,3101	Supplier	
Root					Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data									•				
Equip/Tooling	_												
Operator	_												
Material												Į.	
Setup	_												,
Other	_						1		·				
Process	_												
Supplier	\dashv											<u> </u>	
Training													
Unapproved								T CATE	COBY		1		
Landir	ne G	iear		· · · · · ·		General	AUL	CATE		,			
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	\vdash		ion Incomplete		Part Incorre	ct	Weld
	-	Crushed/0	Crimped,			Burrs	\vdash		ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs	•			Contamination	\sqcap	Mainte	enance		Part Moved	· L	-
		Heat Trea	t			Countersink		Mislabe	eled		Positioned \	V rong	
		Inspection	n Strip in	Tube		Cut Too Short	П	Misread	t .		Power Loss/	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration				
		Turning S	equence			Finish		Out of 9	Sequence				N

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 4

January-31-13 9:54:52 AM Item ID: D2938-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle LH Out. 206 **Start Date: Start Qty: 12.00** 1/31/13 **Cust Item ID:** Required Date: 2/22/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Work Center ID Description Run Hours Qty Code Qty Number Stamp 170 Identify as per dwg & Stock Location *170* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 *180* QC 0.00 Memo Quality Control

Mary of

DQA:	Date:

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

											QA Closea:	Date	·
Work Orde	r:				DISPOSITION					AGAINST DE	PARTMENT	PROCESS	
		···			Rework] 		Skid-tube		Crosstube		Water Jet	Engineering
Part N	0.				Scrap	1	ı	Machining	П	Small Fab	Pro	d. Eng. Coor.	Quality
			·		Use-as-is	1	Therm	noforming	П	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo.				Work Order Update			Large Fab		Composite		Supplier	
. .													
Root				Descri	ption of work order update		nitial		Ac.	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng		Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material									,			ı	
Setup													
Other													
Process													
Supplier					•								
Training													
Unapproved			·										
					F	AUL	T CATE	GORY			·-··		
Landin	ng Gear				General							_	
	Bending				Bend		Grain				Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	on Incomp	lete		Part Incorre	ct	Weld
[Crushed/	Crimped.			Burrs		Instruct	ions Incom	plete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
[Cuffs				Contamination		Mainte	nance			Part Moved		
ſ	Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong _	
Ī	Inspectio	n Strip in	Tube	Γ	Cut Too Short		Misread	i			Power Loss/	Surge [Other
Ī	Ripples in	Bend			Drill Holes		Offset						
Ţ	Torque W	/aves in E	xtrusio	n $ abla$	Drawing		Out of (Calibration					
Ī	Turning S	equence			Finish		Out of	Sequence					
Ī	Wave/Tw	ist in Tuk)e		Teolio		Outside	Dirnensio	าร				

Picklist Print

January-31-13 9:54:57 AM

Work Order ID: 96701

Parent Item:

D2938-1

Parent Item Name: Saddle LH Out. 206

96701

D2938-1

Start Date: 1/31/13

Required Date: 2/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	50.0000	1	12			
D6101-00 Saddle Billet, 7075).3							•	**		20	3/02/	06

Location Loc Code Loc Qty MAT042 94840 50

Page 1

		DQA:	Date:	••••
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	e: ·	
Work Orde	r.					DISPOSITION			7	AGAINST DE	PARTMENT	/PROCESS		
Part N	-					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	۱o. ₋					Work Order Update]	mem	Large Fab	Composite		Supplier		
Root					Descri	ption of work order update	Ir	nitial	A	ction	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Des	cription	Date	Verification	QC Inspecto	r
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							FAUL	T CATE	GORY					
Landi	_			•		General		<u>~ · </u>]			
		Bending Centre No Cracks	ot Concer	ntric to	o/s	Bend BOM/Route Broken/Damaged	П	Grain Hardwa Inspect	ire ion Incomplete		Ovalized Over/Under Part Incorre	F	Pressure/Forced Temperature/Cu Weld	re
		Crushed/	Crimped.			Burrs	-		tions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pul	led
	\blacksquare	Cuffs			 	Contamination	\vdash		enarice	<u> </u>	Part Moved			
		Heat Trea				Countersink	\vdash	Mislabe			Positioned \		\neg	
	_	Inspection	•	Tube		Cut Too Short		Misrea	d .	. L	Power Loss,	/Surge	Other	
	Ш	Ripples in			 	Drill Holes	-	Offset						
	Ш	Torque W			n	Drawing	-		Calibration					
		Turning S	equence			Finish		Out of	Sequence					
		Wave/Tw	ist in Tuk	20		Folio	-	Outside	Dimensions					

DART AEROSPACE LTD	Work Order:	96701
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Re					
Dim	Min .	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		. 129	.127	128	.127		
В	0.100	0.140		.130	. 132	. 130	.130		
С	0.100	0.140		- 113	- 113	- 114	. 112		
D	0.210	0.230		, 227	. 271	- 219	0 218		
E	1.245	1.255		1.250	1.250	1.250	1.285		
·F	1.245	1.255		1.250	1.250	1,25D 2.500	1.250		
G	2.495	2.505		2.500	2.500	2.500	7.500		
Н	0.510	0.515		- 512	.512	-512	- 512		
ı	1.572	1.582		1.577	1577	1,577	1.577		
J	2.495	2.505		2,300	2 500	2500	2.500		
K	0.257	0.262		. 258	.258	,258	.258		
L	0.312	0.317		.314	.314	-314	314		
М	0.235	0.240		-238	.138	.738	. 238		
Ν	0.100	0.140		. 122	119		-118		
0	0.540	0.560		. 550	,550	119	1550		
Р	0.490	0.510		.497	.500	.499	.499		
Q	3.715	3.725		3,720	3720	3,720	3.770		
R	2.720	2.760		2,740	2740	2.740	2.740		
S	0.240	0.270		. 251	.251	-250	-251		
Ť	0.100	0.180		. 140	140	.140	140		
C	1.625	1.635		(630	1630	1630	1,630		
V	1.362	1.372		(367	1.367	1.367	1,367		
W	0.316	0.321		, 316	316	.316	36		
X	1.250	1.270		1.259	1259	1.254	1.257		
Υ	1.565	1.585		1.574	1:574	1.574	1 572		
Z	0.178	0.198		-188	881.	182	.88		
AA				,			1,000		
AB									
AC									······································
AD									
AE									
AF		-							
AG									
AH									
	Acc	ept/Rejec	et .						

	•		- A -
Measured by: 'f'O	Audited by	D. (A	DAG.
Date: 3/02/09	Date:	13/02/10	08
		, , , , , , , , , , , , , , , , , , ,	0-83

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM	Gal
			771	727

DART AEROSPACE LTD	Work Order:	96701
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		- 10
Dim	Min	Max	Go/No Go Gauge	1/5	26	<i>3</i> 7	48	Ву	Date
Α	0.100	0.140		. 125	,124	. 125	. i26		
В	0.100	0.140		. 130	128	. 129	128		
С	0.100	0.140		- 114	V114.40	(11')	- 111		
D	0.210	0.230	<u>"</u>	-218	-218	.218	.219		
E	1.245	1.255		1.250	1,250	1.250	1.250		
F	1.245	1.255		1.750	1.250	1.250	1.250		
G	2.495	2.505		2,500	2.500	2.500	2.500		
Н	0.510	0.515		,512	512	. 512	.512		
	1.572	1.582		1.577	1577	1577	1 577		
J	2.495	2.505		2,500	2.50	2.500	2.500		
K	0.257	0.262		7.58	.258	258	258		
L	0.312	0.317		314	.24	314	314		
M	0.235	0.240		-238	.237	237	.238		
N	0.100	0.140		. 11.8	117	. 114	119		
0	0.540	0.560		Sua	<u> 549</u>	,548	-548		
Р	0.490	0.510		•500	.497	. 497	. 497		
Q	3.715	3.725		•500 3,720	3,720	3,720	3.720		· · · · · · · · · · · · · · · · · ·
R	2.720	2.760		2,740	1.740	2,740	2.740		
S	0.240	0.270		,751	.248	.248	-247		
T	0.100	0.180		.140	.140	. 140	- 140		·············
U	1.625	1.635		1.630	1.630	1620	1620		
V	1.362	1.372		1.367	1367	1.367	1.367		
W	0.316	0.321		.36	-316	. 316	.316		
X	1.250	1.270		1.254	1.760	1.257	1.261		
Υ	1.565	1.585		1,569	1,575	1.572	1,576		
Z	0.178	0.198		- 188	188	1.188	188		
AA					3,107	, 40	100		
AB						· · · · · ·			
AC									
AD									
AE									· · · · · · · · · · · · · · · · · · ·
AF	-								
AG		-							
АН									· · ·
	Acc	ept/Rejec	t						

	· · · · · · · · · · · · · · · · · · ·	\circ
Measured by: パク	Audited by	<i>V</i> - <i>Q</i> -
Date: 13/02/09	Date: 13/02/10	08

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat, Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM A	Gul

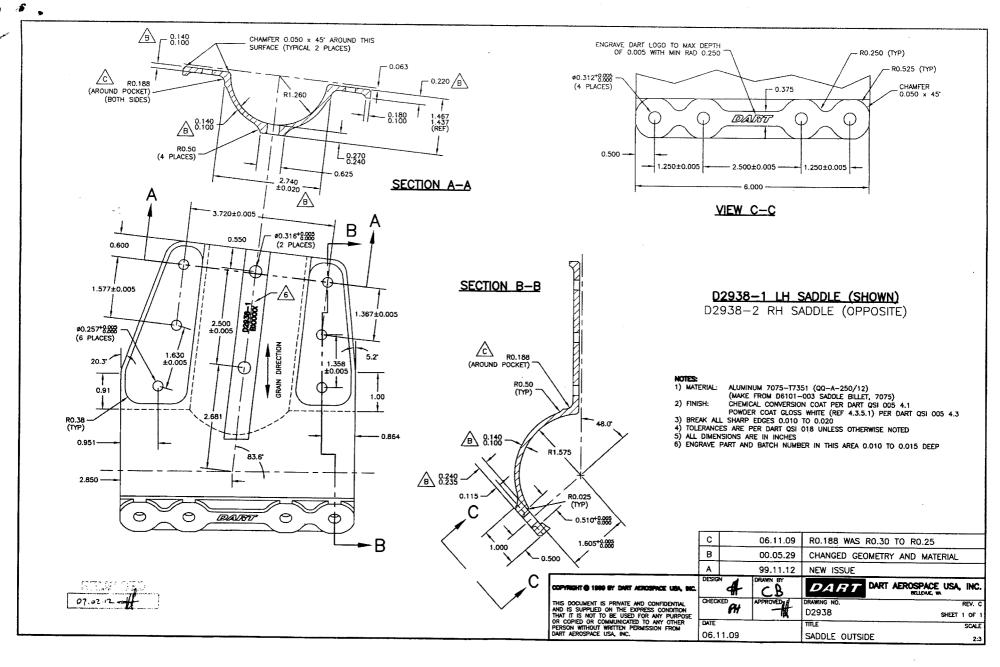
DART AEROSPACE LTD	Work Order:	96701
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

		-		Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	2 q	2 10	2' 11	A 12	Ву	Date
Α	0.100	0.140		. 123	, 120	125	126		
В	0.100	0.140		. 127	.123	.129	.129		
С	0.100	0.140		-110	. (05	-110	. 110		
D	0.210	0.230		₂ 214	-220	. 221	-220		
E_	1.245	1.255		1.250	1,250	1,250	1,250		
F	1.245	1.255		1.280	1.250	1.250	1.250		
G	2.495	2.505		7.500	2500	2.500	2.500		
Н	0.510	0.515		. S12	.512	.512	.512		
	1.572	1.582		1.577	1.577	1,577	1577		
J	2.495	2.505		2,500	2.500	2,500	2.500		
K	0.257	0.262		.758	258	258	.258		
L	0.312	0.317		-314	-314	314	.34		
M	0.235	0.240		-237	-236	.238	.738		
N	0.100	0.140		~ 11O	.122	. 124	.122		
0	0.540	0.560		. 550	.549	7SSO	-550		
Р	0.490	0.510		.499	.497	.498	, 499		
Q	3.715	3.725		3,720	3,720	3 720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2 740		
Ş	0.240	0.270		. 147	. 240	. 248	. 248		
Т	0.100	0.180		,140	- 140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1630		
V	1.362	1.372		1367	1.367	1.367	1.367		
, W	0.316	0.321		.316	.316	-316	.316		
Χ	1.250	1.270		1.256	1.269	1.262	1.261		
Υ	1.565	1.585		1.571	1.584	1577	1.577		
Z	0.178	0.198		· (38)	.188	. 188	1881		
AA				<u> </u>	7				
AB									
AC									
AD									
AE								·	
AF									
AG									····
AH									
	Acc	ept/Rejec	et						

		_	
Measured by: YD	Audited by	ha	OAC
Date: 13 102 10	Date:	13102110	08
			0 00

Rev	Date	Change	Revised by	Approved
_ A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM -	GIII
			77	727



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